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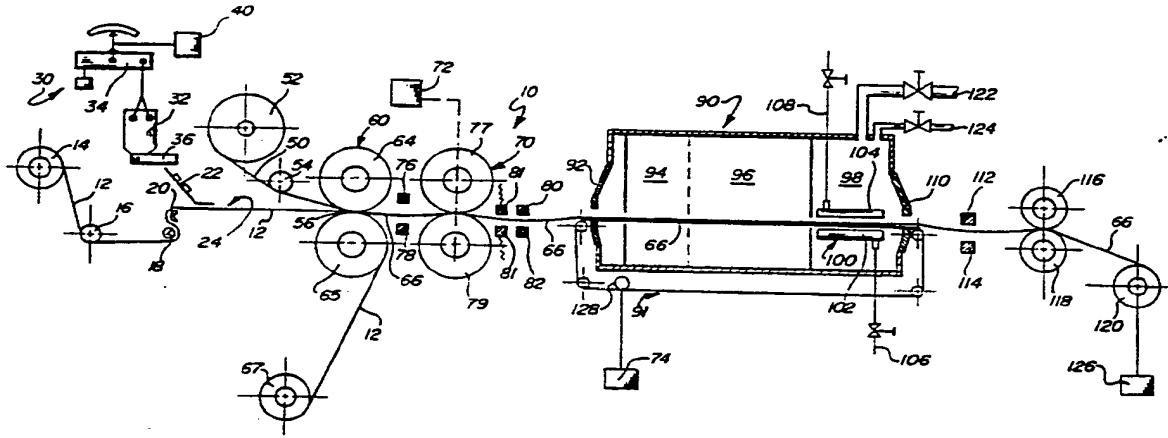
(54) Method and apparatus for making electrode material from high hardness active materials.

(57) A method and apparatus for making electrode material from high hardness active electrode alloy powder involve feeding the powder onto a carrier web (12), aligning a mesh or screen substrate (50) with the carrier web, and compacting the powder and mesh in a series of roller presses (60, 70). The carrier (12) is removed after it has passed through the first roller press, and the remaining green electrode web is passed through the second roller press and into a sintering furnace (90). After sintering and cooling, the web is calendered (116, 118), and then is wound on a take-up reel (120). The furnace provides a substantially water and oxygen-free argon-hydrogen atmosphere for sintering which discourages web oxidation at the elevated sintering temperature. A

loss-in-weight feeder (30) can be used to deposit accurately the desired amount of active material on the carrier web.

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FIG. 1



METHOD AND APPARATUS FOR MAKING ELECTRODE MATERIAL FROM HIGH HARDNESS ACTIVE MATERIALS

This invention relates generally to the production of sheets of electrode material for batteries, and more particularly, concerns a method and apparatus for continually producing an elongated negative electrode sheet or web.

Secondary batteries, also known as rechargeable batteries, are finding increasing commercial favor in a variety of applications. Some of these batteries comprise a negative electrode which is capable of reversibly electrochemically storing hydrogen. The negative electrode contains an active material which may be a metal alloy comprised of titanium, nickel and usually other materials. Other metallic alloys can also be used as the active material. Suitable alloys are disclosed in U.S. Patent No. 4,551,400, for example.

The production of these negative electrodes is sometimes difficult because many hydrogen storage active materials are not very ductile, and they are of relatively great or high hardness. Indeed, these alloys can have a Rockwell "C" (R_C) hardness of 45 to 60 or more. Usually the alloy is formed from a melt, and the resulting alloy material must then be crushed or otherwise worked before the material is fabricated into an electrode. The alloys are usually utilized in powdered form in the manufacture of the electrode. These powder takes the form of small ash or flake-like particles which after suitable treatment will pass through a 200 U.S. mesh screen, and thus are smaller than 38 microns in size (200 U.S. mesh screen has interstices of about 75 microns).

Various methods of manufacturing electrode strip have been previously offered, but these methods and their associated equipment cannot be used with the high hardness, flake or ash-like active powdered material involved here. For example, a system for making battering plates is suggested in U.S. patents 3,894,886 and 3,951,688, but that system involves using an electrochemically active thixotropic paste.

Another method of making electrode strip involves feeding a free-flowing silver powder to a moving paper web. Vibrating doctor blades spread the powder on the carrier to a pre-determined thickness. A silver grid structure or mesh is introduced to the powder and carrier. A single rolling mill compresses the grid and powder on the carrier, and then the carrier is withdrawn. The remaining web is then sintered. After the sintered silver strip leaves the sintering furnace, it is cut into strips for use in silver-zinc battery cells.

This system cannot be used with the high hardness active powdered material involved here, because the present powder does not act in the same way as the silver powder and mesh in the silver electrode production line and production equipment. When the high hardness powder used here is compressed on a paper carrier, the powder particles stick to or become embedded in the paper. Web tearing or other web damage can result. In addition, the present invention contemplates depositing a relatively thin layer of flake-like particles on a smooth, hard carrier. It has been found that doctor blades are ill-suited to provide a precisely controlled thickness or depth of powder, because the powder flakes or ash-like particles tend to commingle and build up in front of the blades. A powder layer of irregular thickness and density and occasionally inadequate depth results. Uniformity of powder depth and amount of active material per unit area is necessary to provide a uniform electrode strip. A uniform strip thickness is essential for battery electrodes if finished battery design capacity and performance are to be achieved.

Accordingly, a need exists for a production method and production apparatus capable of making electrode strip from a very hard flake-like powder feed stock material. More specifically, a need exists for a method and apparatus to form negative electrode strip material from powdered alloy materials having a Rockwell "C" hardness (R_C) of 45 to 60 or more. As used here, the term "high hardness" will be understood to refer to a Rockwell "C" hardness of 45 to 60 or more.

Summary of The Invention

This invention provides a method and apparatus for making electrode material from high hardness active electrode alloy powder that may be flake-like or ash-like and irregularly shaped.

Generally, the method includes the steps of feeding the high-hardness powder onto a hard, strong carrier web, which can be polyester, from a suitable feeder, which can be a loss-in-weight feeder. A mesh or screen electrode substrate is aligned with the carrier web, and the powder and mesh is compacted by a suitable device, which can be a series of at least two rolling mills. The carrier web is removed, and the remaining self-supporting electrode web can be passed into a sintering furnace. The sintering furnace provides a substantially water and oxygen-free argon-hydrogen atmosphere for

sintering which discourages web oxidization at the elevated sintering temperature. After sintering and cooling, the web can be calendared and then is wound on a take-up reel.

In accordance with one aspect of the present invention, the method of making an electrode from high hardness active powdered material includes the steps of feeding a measured amount of a high hardness active powdered material onto a carrier web, aligning a substrate with the carrier web, feeding the carrier web, substrate and powdered material to at least two roller mills in series and compacting the powdered material and substrate through at least two roller mill compactions to achieve an electrode web of at least sufficient strength to allow sintering and removing the carrier web from the electrode web.

In accordance with another aspect of the present invention, a method of making an electrode from high hardness powdered active material is provided that includes the steps of feeding powdered active material onto a carrier web with a loss-in-weight feed device, aligning substrate with the carrier web and feeding the substrate, carrier web and powdered material to a compacting device, that may be a roller mill, thereafter compacting the powder and the substrate in the compacting device whereby a self-supporting electrode web comprising the active material and substrate is provided having at least sufficient strength to allow sintering and removing the carrier web from the electrode web.

In accordance with still another aspect of the present invention, an apparatus for making an electrode from high hardness powdered active material is provided. The apparatus includes a feeding device for feeding the powdered active material onto a carrier web, structure for providing a substrate to the carrier web and the powder carried thereon and a compacting device comprising two roller mills in series for successively compacting the powdered active material onto and into the substrate to form an electrode web capable of being self-supporting after compaction by the first roller mill. The feeding device is preferably a loss-in-weight feeder. Structure for removing the carrier web from the electrode web after compaction by the first roller mill to leave a self-supporting electrode web is provided. The apparatus can further include a sintering furnace for sintering the compacted powdered material and substrate.

In accordance with another aspect of the invention, the apparatus for making an electrode is provided that includes a loss-in-weight feeding device for feeding high hardness active electrode material onto a carrier web, structure for feeding a substrate onto the carrier web bearing the powder, a compacting device for compacting the powder and sub-

strate on the carrier whereby an electrode web is formed having at least sufficient strength to be self-supporting and structure for removing the carrier web to leave a self-supporting electrode web having at least sufficient strength to allow sintering.

In accordance with another aspect of the invention, the apparatus for making an electrode from high hardness powdered active material, such as a Rockwell hardness of 45 or more, includes an elongated carrier web having a tensile strength of at least about 10,000 psi and Rockwell Method A hardness (R_A) of at least about 90, structure for feeding high hardness powdered active material onto the carrier web at a pre-selected rate, structure for providing an elongated substrate in alignment with the carrier web, structure for compacting the powdered active material on the carrier with the substrate to produce an electrode web composed of the active material and the substrate, the electrode web having at least sufficient strength to be self-supporting and to allow sintering. The apparatus further includes structure for advancing the carrier web from the feeding structure to the compacting device and also structure for advancing the substrate in alignment with the carrier web to the compacting device. Structure for separating the carrier web from the electrode web is also provided. The electrode web may then be sintered in a suitable sintering furnace.

Brief Description of The Drawings

Figure 1 is a schematic illustration of an arrangement of equipment for producing the electrode material in a continuous strip form; and

Figure 2 is a developed elevational view of part of the equipment shown in Figure 1.

Turning first to Figure 1, there is shown, in schematic form, a production line for producing a continuous negative electrode strip from a negative electrode powder material of the type described above.

To move the powdered material through at least the first portion of the production process, a removable carrier web is provided. Generally, the carrier web is not reusable and can be a suitable polymer film material such as polyester, nylon, acetate polymers including cellulose acetate and vinyl acetate and flexible metals such as aluminum, steel and alloys thereof. Carriers made of such polymers and metals have essentially no porosity in which particles could embed, unlike paper, for example. This is one of the reasons paper cannot be used. Preferably, the carrier web is a polyester plastic film material. One especially suitable film is Mylar polyester film, from E.I. DuPont de Nemours and Company of Wilmington, Delaware. Preferably,

the film material is less than 20 mils thick, and most preferably it is 5 mils thick. The carrier web has a smooth surface and it has a hardness and porosity sufficient to resist particle embedding adherence during particle and carrier compression in a rolling mill.

Generally, a hardness of more than about R_A (Rockwell Method A) 90 is sufficient and preferably the hardness is about R_A 115 or more. The carrier web should also have a tensile strength sufficient to resist stretching during its use. Generally, a tensile strength of about 10,000 psi or more is sufficient and preferably film having a tensile strength of about 45,000 psi is used. Alternatively, this carrier web can take the form of a polyester film for contact with the active material and kraft paper laminate. It is contemplated that, in one embodiment, the carrier web will move through the manufacturing line at a constant speed of about 2.5 feet per minute.

In the production line illustrated in Fig. 1, a carrier web 12 is lead from a feed roll 14 past an idler roller 16 and through a tensioning roller 18. Carrier web 12 then passes over a curved final positioning shoe 20 so as to travel closely underneath an inclined delivery slide 22 and conveyor pan 23. A powder loading region 24 of web 12 is located downstream at conveyor pan 23.

The active negative electrode material, in its original dry feed stock powdered form, generally together with a suitable type and amount of binder material, such as up to about 7 weight % of powdered nickel, is dispensed from a loss-in-weight feeder device 30. The binder material can aid in the sintering process to achieve the desired mechanical integrity. The binder does not aid in the compaction process to achieve green strength as do organic thixotropic additives or adhesives. Water and slurry mixes are not used because unacceptable oxidation of the active material would occur. As schematically illustrated here, the dry powder can be stored in a suitable feeder bin 32 which is connected to a weighing device 34. To deliver powder from bin 32 to slide 22 at a uniform rate, a delivery device such as a screw conveyor 36 is provided. Material is deposited from slide 22 onto conveyor pan 23 which extends generally horizontally along web 12 and which can be vibrated suitably to facilitate depositing the active material onto web 12. For example, the vibration may be a cyclical oscillation consisting of a first cycle comprising movement in a vertical direction away from the web concurrent with movement in a horizontal direction in the direction of web transport and a second cycle comprising movement in the opposite

directions, namely movement in a vertical direction towards the web concurrent with movement in a horizontal direction in the opposite direction of web transport.

5 Weighing device 34 is connected to a micro-processor or other numerical control device 40. Numerical control device 40 can be connected to screw conveyor 36 and to downstream web speed monitoring devices. Numerical control device 40 is
10 programmed to automatically adjust the powder delivery of screw conveyor 36 so as to deposit the active powder material in loading region 24 at a weight rate calculated to provide material at a uniform weight per unit area. If the carrier movement
15 speeds up, more powder is at once delivered; if the carrier slows down, less powder is provided. Thus, this loss-in-weight delivery mechanism deposits the powdered negative electrode active material on the carrier web at a highly uniform weight per unit
20 area. In this way, a precisely controlled weight of powdered anode material is delivered to each measure of carrier area. No doctor blades or other imprecise adjustment devices are needed. In fact, doctor blade devices have been found to be unacceptable for the types of materials that this apparatus
25 is capable of processing.

Delivery slide 22 is more fully illustrated in Fig. 2. Material deposited on slide 22 encounters material divider elements taking the form of small triangles 42 ordered in an extending and descending cascade array. To help provide uniform material flow stream to web 12 a vibrating mechanism 44 is provided for vibration in a manner as previously described of conveyor pan 23, which in this
30 case also vibrates slide 22, slide 22 being rigidly connected to conveyor pan 23. It is contemplated that the layer thickness of powder deposited upon the carrier will generally be on the order of 60 to 70 mils, which may be only about fifteen to twenty particles, or less, for some types of active materials. Typically, for example, the amount of active
35 powdered material per square centimeter deposited on the carrier may be about 0.17 grams.

Next, a mesh electrode substrate 50 is aligned with carrier web 12 and introduced to the powder on carrier web 12. Electrode substrate 50, in this case, is a continuous web of nickel mesh provided in the form of a roll 52. In this embodiment, the nickel mesh takes the form of a 20 x 20 mesh of 7
40 mil wire, but other forms of mesh could be used. For example, a 10 x 40 mesh of 5 mil wire has been found acceptable. Alternatively, nickel-plated steel wire mesh could be used, or the substrate could take the form of Exmet brand expanded metal or other suitable forms.
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50
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As shown in Fig. 1, substrate mesh material 50 passes a curved final positioning shoe 54 and meets the powder and carrier web 12 at the nip 56 of the first of a series of several roller mills 60, 70. In accordance with one aspect of the invention, the powder and substrate are compacted together by a series of compaction rollers into an electrode web having a minimum green strength with a compacted density of about 4-8 and preferably about 6 grams per cubic centimeter and about 15-30% porosity. It is believed that some porosity is needed to provide optimum contact between the finished batter electrode and the battery electrolyte. If desired, the mesh could be introduced prior to the nip of the first roller press but a final electrode web having direct bending and/or electrochemical properties would be produced because the mesh may be at a different location relative to the active material. Thus, the mesh could be positioned at the center of the active material, for example.

In carrying out the invention, it is preferred to provide two roller presses 60 and 70. In the first roller press 60, the rollers 64 and 65 address each other with a roll force of about 50 tons and compact the incoming mesh and powder with a pressure of, preferably, 1 to 7 tons per square centimeter. When so compressed, the powdered material and substrate adhere in a continuous electrode web 66 consisting of the active material, substrate and binder (if present) having a thickness of about 20 mils and at least sufficient green strength which will permit electrode web 66 alone to be self-supporting and withstand subsequent handling. After the material and carrier web 12 pass through first roller press 60, carrier web 12 is stripped away from freely suspended green electrode web 66. Carrier web 12 can be wound upon a take-up roll 67 and subsequently discarded.

First roller press 60 is driven so as to provide a small amount of slack, as illustrated in Fig. 1. Slack sensors 76, 78 can be imposed between roller presses 60 and 70 to sense the amount of slack provided, and to provide corresponding signals to the roller press control processor 72. Roller presses 60 and 70 do not operate at precisely the same speed because the powder and mesh being compressed deforms and elongates as it moves between the rolls.

To provide the final compaction necessary so as to provide the desired porosity, which may be about 15-30%, for example, second roller press 70 includes two rolls 77, 79 which address each other and interposed green electrode web 66 with a pressure of preferably about 7 to 14 tons per square centimeter or a roll force of about 50 tons.

Electrode web 66, consisting of the substrate and active material with binder, is reduced to a thickness of about 15 mils by this second roller press 70.

Although a single roller press can provide the necessary compaction, it has been discovered that use of a single roller press requires such high operating pressures as to make press purchase and maintenance relatively expensive. In accordance with this aspect of the invention, then, the provision of two 75 ton capacity roller presses operated in series as disclosed here provide the requisite pressures and material transformations at a relatively modest cost. In addition, a second compaction with the carrier web having been removed, allows improved control and uniformity of the final electrode web properties including the web density.

It has been found helpful to configure at least the first rolling press rolls with concave crowns of one to five mils. These rolls provide good material compaction near the center of the web, and inhibit web and carrier wander movement as they move through the rolling presses. The second press rolls can also be concave crowned, generally to a lesser degree.

To adjust the web thickness, the presses are provided with turn down wheels operated by stepper motors. These motors adjust roller positions to provide the desired roller spacing or interengagement. This arrangement permits roll adjustment as precise as 0.1 mil, although adjustments are usually made in 1.0 mil increments.

The now fully compacted green web 66 passes out of second roller press 70, and a slight amount of slack is provided. To this end, additional slack sensors 80, 82 are connected to transport conveyor drive controller 74 so as to adjust transport conveyor speed and web movement speed. A thickness gauge 81, preferably a non-contact thickness gauge, is provided after roller press 70 to measure the electrode web thickness to provide information for controlling the position of the rollers (roller spacing).

Green electrode web 66 then passes into the sintering furnace 90 to develop mechanical integrity in the finished electrode web product.

To move green electrode web 66 through the furnace without excessive strain, transport conveyor 91 is driven by a motor drive 128. Sintering occurs in a substantially oxygen-free atmosphere. Preferably, the atmosphere consists of approximately 96% argon and approximately 4% hydrogen, by volume. To avoid oxidizing the web, the sintering atmosphere within furnace 90 is maintained substantially free of oxygen and water, usually at a level of less than 20 parts of oxygen per million parts of atmosphere, and preferably, the

oxygen present in the sintering furnace is less than one part per million. Atmospheric moisture levels are preferably maintained at a dew point of -50°C to -65°C to inhibit web oxidization. The small amount of hydrogen is provided to prevent oxide formation on the active material and to encourage reduction of residual oxygen. Gas is provided by argon valve 122 and by hydrogen valve 124. Even gas distribution is provided by a suitably designed plenum.

To maintain the integrity of the oxygen-free atmosphere, a low profile gas gate slot mechanism 92 is provided at the upstream end of the continuous sintering furnace 90 and the sintering atmosphere is at positive pressure with respect to the external atmosphere.

After passing through gate 92, the electrode web enters a pre-heat zone 94 in which a temperature of 25° to 100° centigrade is provided. The low profile presented by the gas gate extends throughout the pre-heat zone. The profile is less than one inch. In the pre-heat zone, any absorber water which may be presented in green electrode web 66 is driven off. It has been found useful to make this pre-heat zone approximately 16 feet long for the web movement speeds contemplated here.

After moving through the pre-heat zone, green electrode web 66 enters a sintering zone 96 which is of a suitable length to provide the desired degree of sintering at the operating temperature and web speed contemplated. The sintering zone profile is much higher than the gas gates and is approximately 12 inches. A preferred temperature range is approximately 950° to 1050° centigrade. About 20-24 feet is a suitable length for the contemplated operating conditions. A plurality of sub-zones of varying temperatures can be utilized as desired.

The hot sintered electrode web 66 is then passed through a cooling zone 98 of suitable length, in this case about 18-20 feet. The entire cooling zone has the same low profile as the entrance pre-heat zone. A hydrogen-enriched atmosphere can be provided by a plenum or other device to discourage web oxidization. Alternatively, the atmosphere may be the same throughout the pre-heat, sintering and cooling zones. To encourage rapid yet controlled cooling, this cooling zone 98 is provided with a heat exchanger 100 having a lower water-cooled element 102 and an upper water-cooled element 104 located close to the hot web 66. Incoming cool water can be provided through suitable piping 106; relatively hot water is discharged through appropriate piping 108.

The cooled and sintered web then passes through an exit gas gate 110, which provides a corresponding signal to take-up roller control processor 126. Again, it is desired that slack be provided in the web 66, and to that end, slack controllers 112, 114 are located just downstream of the exit gas gate 110.

In the preferred form of the invention, the cooled and sintered web 66 is then calendared by passing it through calendaring rolls 116, 118 which generally are set to apply a pressure in the range from about 0.2 to 1.0 ton per square centimeter. The calendared web 66 is then wound on a take-up roll 120. Completed roll 120 of product can then be removed and transported to other sites for battery manufacture.

Claims

1. A method of making an electrode from high hardness active powdered material, the method comprising the steps of feeding a measured amount of a high hardness active powdered material onto a non-porous carrier web (12); aligning an electrode substrate (50) with the carrier web (12); passing the powdered material and electrode substrate (50) through at least two roller press (60,70) compactions in series to produce an electrode web (66) composed of the active material and the electrode substrate (50), of at least sufficient strength to allow sintering; and, with the carrier web (12) removed from the electrode web (66), sintering the electrode web.

2. A method according to claim 1, wherein the carrier web (12) is less than 20 mils thick.

3. A method according to claim 1 or claim 2, wherein the carrier web (12) has a tensile strength of at least 10,000 psi and an R_A hardness of at least 90.

4. A method according to any one of the preceding claims, wherein the feeding step includes the step of feeding the powdered material onto a carrier (12) from a loss-in-weight feeder (30).

5. A method according to any one of the preceding claims, wherein initial roller press compaction (60) of the active material and electrode substrate (50) produces an electrode web (66) that has sufficient strength to be self-supporting and the carrier web (12) is removed from the electrode web (66) before the final roller press (70) compaction.

6. A method according to any one of the preceding claims, wherein the powdered material is compacted by more than 50% by volume.

7. A method according to any one of the preceding claims, wherein the carrier web (12) is fed to the initial rolling press (60) at a substantially constant rate of speed.

8. A method according to any one of the preceding claims, wherein the powdered material fed to the carrier web passes a screen of 200 U.S. mesh.

9. A method according to any one of the preceding claims, wherein the electrode web (60) is compacted to a final density of 15 to 30% porosity.

10. A method according to any one of the preceding claims, wherein the alignment step includes the step of aligning an electrode substrate screen (50) with the carrier web (12).

11. A method according to any one of the preceding claims, wherein the electrode web (66) is sintered in an atmosphere comprising argon and hydrogen, and substantially free of oxygen and water.

12. A method according to claim 11, wherein oxygen comprises less than 20 parts per million of the atmosphere.

13. A method according to any one of the preceding claims, wherein the hardness of the active material is greater than R_C 45.

14. A method according to claim 13, wherein the hardness of the active material is from R_C 45 to R_C 60.

15. A method according to any one of the preceding claims, further comprising the step of calendaring the sintered electrode web (66).

16. A method according to any one of the preceding claims, wherein the carrier web (12) comprises material selected from the group consisting of polyester, acetate polymers, nylon and flexible metals.

17. A method according to claim 16, wherein the carrier web (12) is a polyester carrier (12) having a tensile strength of substantially 45,000 psi and a hardness of substantially R_A 115.

18. A method of making, by compaction with a roller press (60, 70), an electrode from high hardness active powdered material having an irregular flake-like particle shape and with a thickness is 20 times or less of the particle size to be compacted, wherein the material is fed to the carrier by metering the material from a loss-in-weight feeder (30).

19. Apparatus for making an electrode from high hardness powdered active material by a method according to any one of the preceding claims, the apparatus comprising feeding means (30) for feeding the powdered active material onto the carrier web (12); substrate provision means (52) for providing an electrode substrate (50) to the carrier web (12) and the powdered active material carried thereon; compacting means comprising at least first (60) and second (70) roller presses in series for successively compacting the powdered material with the substrate (80) to form the electrode web (66) capable of being self-supporting; carrier web removal means (67) for removing the carrier web

(12) from the electrode web (66) after at least compaction sufficient to leave a self-supporting electrode web (66); and sintering means (90) for sintering the compacted electrode web (66).

20. Apparatus according to claim 19, wherein the first roller press (60) has rollers that are concave crowned in an amount of from 1 to 5 mils.

21. The apparatus according to claim 19 or claim 20, wherein the feeding means comprises a loss-in-weight feeder (30).

22. Apparatus according to claim 21, wherein the feeding means further comprises an inclined delivery slide (22) for receiving material from the loss-in-weight feeder (30) and depositing the material on the carrier (12).

23. Apparatus according to claim 22, further comprising vibrating means for vibrating the delivery slide.

24. Apparatus for making an electrode from high hardness active material, the apparatus comprising loss-in-weight feeder means (300) for feeding powder onto a carrier web (12); substrate feed means (52) for feeding an electrode substrate (50) onto the carrier web (12) bearing the powder; compacting means (60, 70) for compacting the powder and electrode substrate (60) on the carrier web (12) whereby an electrode web (66) comprising the substrate (50) and the active material is formed that has at least sufficient strength to be self-supporting; carrier removal means (67) for removing the carrier web (12) from the electrode web; and means (90) for sintering the electrode web.

FIG. 1

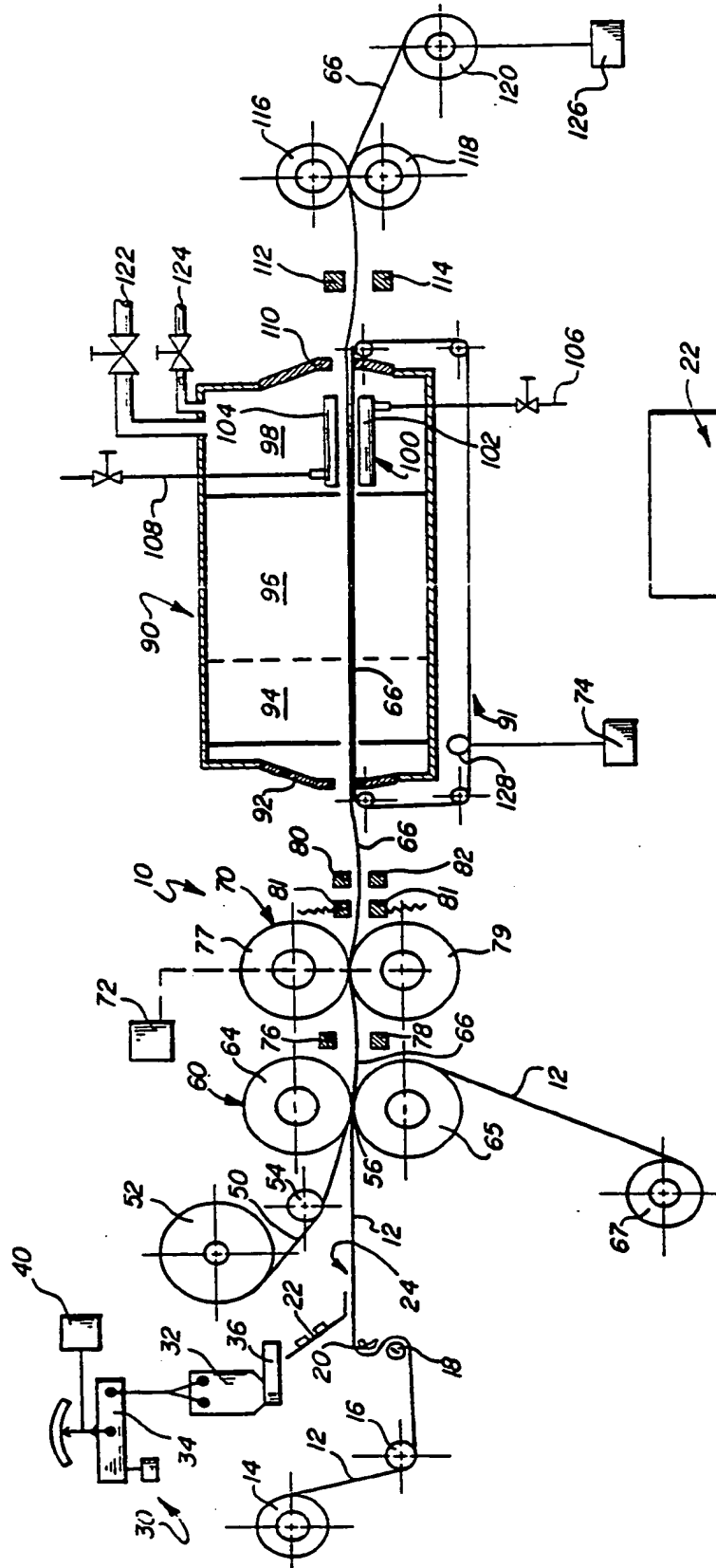
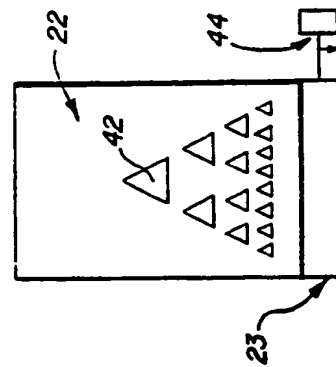


FIG. 2





European Patent
Office

EUROPEAN SEARCH REPORT

Application number

EP 87302626.4

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
A	US - A - 3 272 654 (LANG) * Fig. 1; claims 1,6 * --	1,10, 19,24	H 01 M 4/28 H 01 M 4/30 G 01 G 13/20
A	US - A - 3 121 029 (DUDDY) * Fig. * --	1,5,15, 19,24	
A	DE - B - 1 233 926 (VOGT) * Fig. 1; column 2, lines 39-41 * --	1,4,19, 21,24	
A	ULLMANNS ENCYKLOPÄDIE DER TECHNISCHEN CHEMIE, 4th edition, vol. 5, 1980 VERLAG CHEMIE, Weinheim page 884 * Fig. 8.6., chapter 3.1.2. * --	1,4,19, 21,24	
D,A	US - A - 3 894 886 (PANKOW et al.) * Fig.; abstract * --	1,5,10, 19,24	
D,A	US - A - 4 551 400 (SAPRU et al.) * Abstract * ----	1	
The present search report has been drawn up for all claims			
Place of search VIENNA		Date of completion of the search 12-08-1987	Examiner LUX
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	